Page 1

January 19, 2010 9:50:40 AM

Item ID:

D3512-1

Revision ID: Item Name:

Wearplate

Start Date: Required Date: 1/25/10

1/19/10

QC:

Start Qty: 8.00 Req'd Qty: 8.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Date: 16-1-19 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Reject

Qty

Stop

10-1-25



Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Number Stamp

Insp.

Draw Nbr

Revision Nbr

D3512

Rev C

100

Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

0.00

1-Cut as per Dwg D3512 | Dwg Rev: C | TiProg Rev: C | Ti2-

Deburr if necessary

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

OC8- Inspect parts - second check

Memo

0.00

B 10-1- 28

Quality Control

120

QC

2) Sioloilos

Quality Control

Dart Aerospace Ltd

	. Johaco E	•••							
W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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yu.									
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	s No DO	A:	Date: _	
	Res	olution:						Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC						Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Dai		tion C	Chief Eng	QC Inspector
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January 19, 2010 9:50:40 AM

Item ID:

D3512-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Wearplate

1/19/10

QC:

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Required Date: 1/25/10

Date:

Tooling:

Date:

Run

Stop

Start

Approvals:

Process Plan:

Date:

SPC (Y/N):

Date:

Plan

Code

Sequence ID/ Work Center ID Operation **Description** Set Up/ **Run Hours** Draw Number

Draw Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

NC BRAKE

0.00

Deburr if necessary! Form as per dwg D3512 using DT8179 S (001) 28

140

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

150

Large Fab Large Fab

Large Fab

0.00

F- 10-2-1

Memo

Memo

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004. Qty
Description Batch: A/R 2059b Hardcoat Rod MI1343

Dart Ae	rospace Ltd							,
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	В	y Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: \	'es No	DQA:	Date: _	J
Resolution:		ution:	Disposition:	QA: N/	Date:			
NCD:			WORK ORDER NON-CON	FORMANCE (N	ICR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B				Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector			
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		711					4				
	1		1 1					ľ			



January 19, 2010 9:50:40 AM

Item ID:

D3512-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearplate

Start Date:

Required Date: 1/25/10

1/19/10

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC10- Inspect visual per QS1004- ground welds

Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Memo

2) 8 10/02/01

0.00

170

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

=> Sider loi

180

Powdercoat Powder Coating Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

11112588

Memo

Memo

START TIME: 1\30p_CFINISH TIME:

=> JU 10/02/10 OVEN TEMPERATURE:

Dan Ae	ospace	ELLA								
W/O:			W	ORK ORDER CH	ANGES					•
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						3				
Part No	:	PAR #:	Fault Cate	egory:	NCI	R: Yes N	lo DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:		V	ORK ORD	ER NON-CONFC	RMANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Seci		Offier Eng	QO INSPECTO

Work, Order ID 55466

January 19, 2010 9:50:40 AM

Required Date: 1/25/10

Page 4

Item ID:

D3512-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Wearplate

1/19/10

QC:

Start Qty: 8.00

Req'd Oty: 8.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date: Date: **Tooling:**

Date:

Start

Run

Stop



Sequence ID/ Work Center ID

190

Quality Control

Operation Description

QC3-Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

SPC (Y/N):

0.00

Date:

Draw Rev.

Plan Code

10-02-11 (To

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging Packaging

200

Identify as per dwg & Stock Location:

0.00

Memo

0.00

[com/2/11 (12

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:				
		solution:	Disposition):	_ QA: N/C	Closed:		Date: _				
			WORK ORDE	R NON-CONFORMA	NCE (NC	R)						
	OTED	Description of NC	[on B	Verifi	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	Verification Section C	Chief Eng	QC Inspector			
						1						
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Picklist Print

January 19, 2010 9:50:44 AM

Work Order ID: 55466

Parent Item Name:

Parent Item:

D3512-1

Comments:

Wearplate

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Now SS as per Rev B 06-12-15 JLM

IPP Rev:C Rev C dwg 07-12-06 DD

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 8.00 Required Qty: 8.00

Component Item ID/ M304S16GA

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 100

Unit of sf

Qty on

Remaining 260.9779 2.1979

Qty

Date Status

1B10-1-25

Page 1

304/316 Sheet .063

Loc Qty Loc Code Warehouse

197.8895

Location

Main Warehouse

113295

MAT 260.9778737 106860 8.0295 111924 25.1689737 112442 29.8899

3

Dart Ae	rospace	Lia								,			
W/O:			WORK ORDER CHANGES .										
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Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	_ Date: _				
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DATE	STEP	Description of NC			Section B			cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign & Date		ion C	Chief Eng	QC Inspector			
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DART AEROSPACE LTD	Work Order:	55-464
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

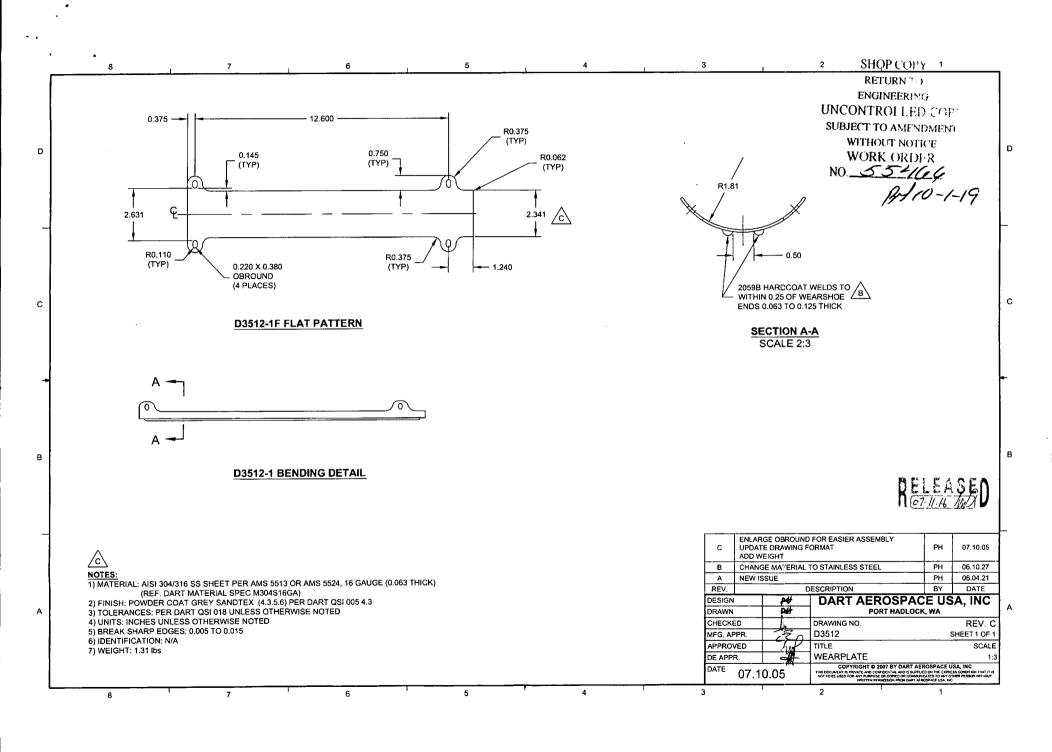
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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12.600	+/-0.010	00d. Gi	d			
0.145	+/-0.010	1147	7			
0.750	+/-0.010	:153	8			
2.631	+/-0.010	2,630	স			
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10-1-35	Date: coluctos	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM 1.0	
В	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	N.

Dart	Aer	osp	ace	Ltd
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W/O:			WC	RK ORDER CHANG	ES				
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NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	1)			
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Dart Aerospace Ltd

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DATE	STEP	Description of NC	Corrective Action State Initial Action Description		tion B	Sign & Sec		ication Approval		
		Section A	Chief Eng	Chief Eng		Date	Section C		Chief Eng	QC Inspector
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